

**Work Order ID 66236**

February 8, 2011 8:43:37 AM



Page 1

Item ID: D3535-23

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 2/08/11 Start Qty: 12.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 12.00



Customer:

Reference:

Run Start

Approvals: Process Plan: CY Date: 11/02/08 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3535	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535 ☒ Dwg Rev: B ☐ Prog Rev: B ☐ 2-321.40

Debur if necessary

B11-2-15(13)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-2-15

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

S 11/02/16(13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 66236**

February 8, 2011 8:43:37 AM



Page 2

Item ID: D3535-23

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 2/08/11 Start Qty: 12.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326 2-Form  
joggle as per Dwg D3535 using Jig DT8158 3-Identify as D3535-23

Sp 11/02/11

13

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Sp 11/02/11

(13)

150

0.00



Grey Sandtex(Ref:4.3.5.6) per OSI005 4.3

Powdercoat

Memo

0.00

Powder Coating

START TIME: 1:05 OVEN TEMPERATURE:  
320° FINISH TIME: 1:35

M 115 108

13

BR 11-2-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 66236**

February 8, 2011 8:43:37 AM



Page 3

Item ID: D3535-23

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 2/08/11 Start Qty: 12.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

13 4 HP 11/02/2011

170

Identify as per dwg & Stock Location: *FP-21* 0.00

Packaging

Memo

0.00

Packaging

13 BR 11-2-23

180



QC21- Final Inspection - Work Order Release 0.00

QC

Memo

0.00

Quality Control

11/02/24 *HA*  
13 *HA* 11/02/23*ME*  
11-02-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

February 8, 2011 8:43:36 AM

Page 1

Work Order ID: 66236

Parent Item: D3535-23

Parent Item Name: Wearshoe



Start Date: 2/08/11

Required Date: 2/22/11

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-15 JLM  
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S20GA		Purchased	No			100	sf	149.5538	1.3615	17.19789			
-----------	--	-----------	----	--	--	-----	----	----------	--------	----------	--	--	--



304/316 .040 Sheet



1311-2-15

Location

Loc Qty

Loc Code

MAT

149.5538

115953

21.6

116437

52.7538

116623

75.2

116623

13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	66236
<b>Description:</b> Wearshoe		<b>Part Number:</b>	D3535-23
<b>Inspection Dwg:</b> D3535	<b>Rev:</b> B	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.888	*		V 1302	
2.000	+/-0.010	2.000	*		V 1	
4.750	+/-0.010	4.750	*		T 1301	
9.500	+/-0.010	9.500	*		T	
14.250	+/-0.010	14.250	*		T	
17.750	+/-0.010	17.750	*		T	
23.140	+/-0.010	23.140	*		T	
28.530	+/-0.010	28.530	*		T	
33.920	+/-0.010	33.920	*		T	
39.310	+/-0.010	39.310	*		T	
44.700	+/-0.010	44.700	*		T	
48.200	+/-0.010	48.200	*		T	
52.850	+/-0.010	52.850	*		T	
Ø0.188	+0.005/-0.001	.190	*		V	
48.00	+/-0.030	48.00	*		T	
39.00	+/-0.030	39.00	*		T	
32.00	+/-0.030	32.00	*		T	
24.00	+/-0.030	24.00	*		T	
16.00	+/-0.030	16.00	*		T	
8.00	+/-0.030	8.00	*		T	
6.00	+/-0.030	6.00	*		T	
0.300	+/-0.010	.300	*		V	
0.300	+/-0.010	.303	*		V	
0.038	+/-0.010	.038	*		V	

<b>Measured by:</b> RB	<b>Audited by:</b> J	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11-2-15	<b>Date:</b> 11/02/16	<b>Date:</b>	N/A

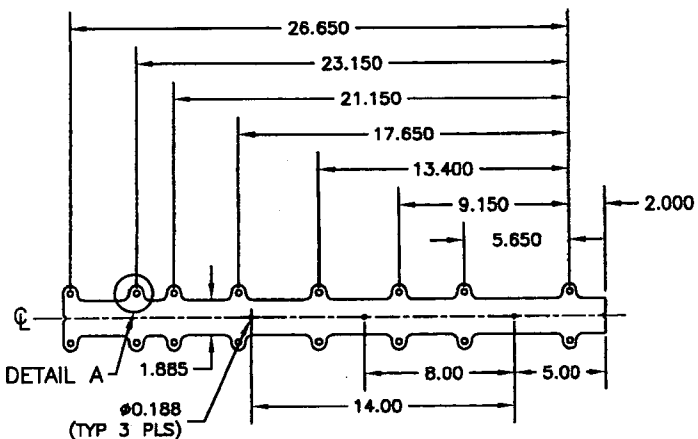
Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	

**DART**

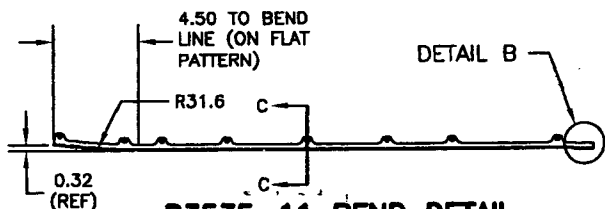
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07.04.24

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CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
<del>PH</del>	<del>PH</del>	D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 1 OF 7
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC

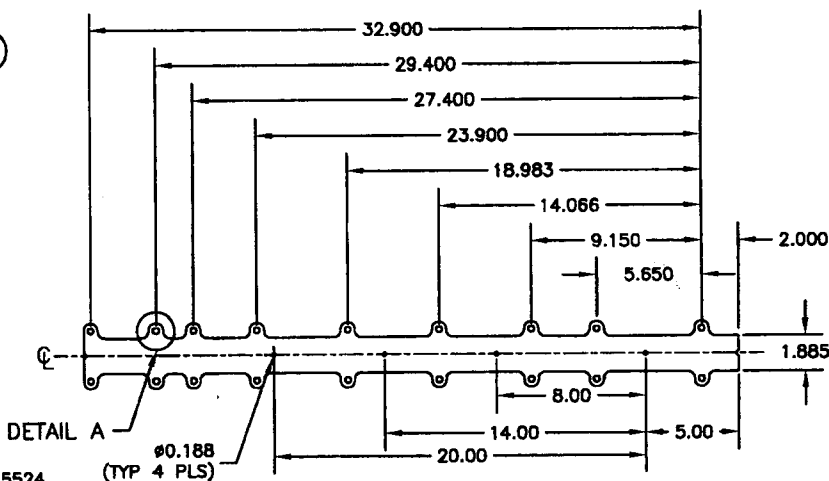


**D3535-11F FLAT PATTERN**

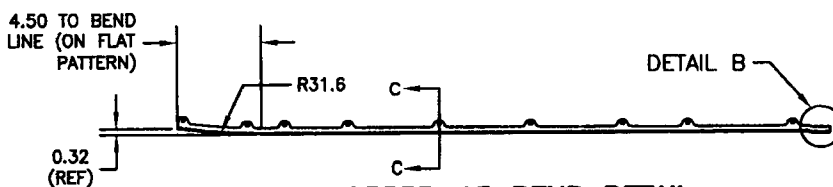


**D3535-11 BEND DETAIL**

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 66236  
02/11/02/108



**D3535-13F FLAT PATTERN**



**D3535-13 BEND DETAIL**

**NOTES**

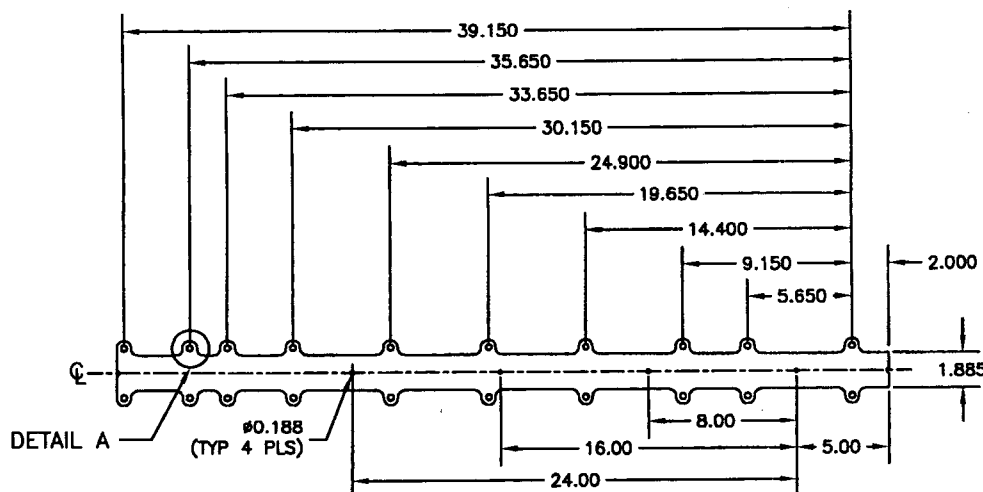
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**DART**

RELEASED

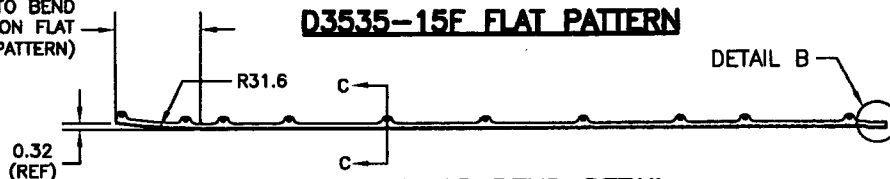
07.04.24

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CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 2 OF 7
		SCALE	1:10	



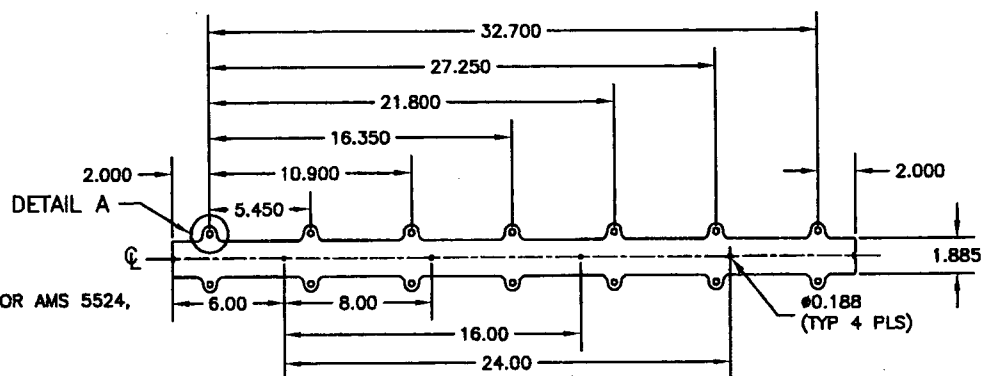
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4.50 TO BEND  
LINE (ON FLAT  
PATTERN)

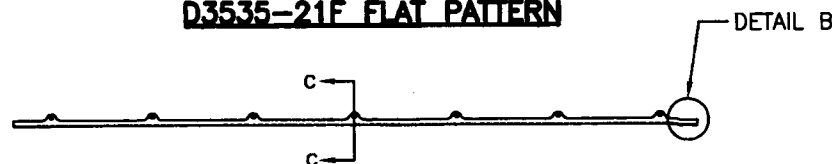


**D3535-15 BEND DETAIL**

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WITHOUT NOTICE  
WORK ORDER  
NO. 66236



**D3535-21F FLAT PATTERN**



**D3535-21 BEND DETAIL**

**NOTES**

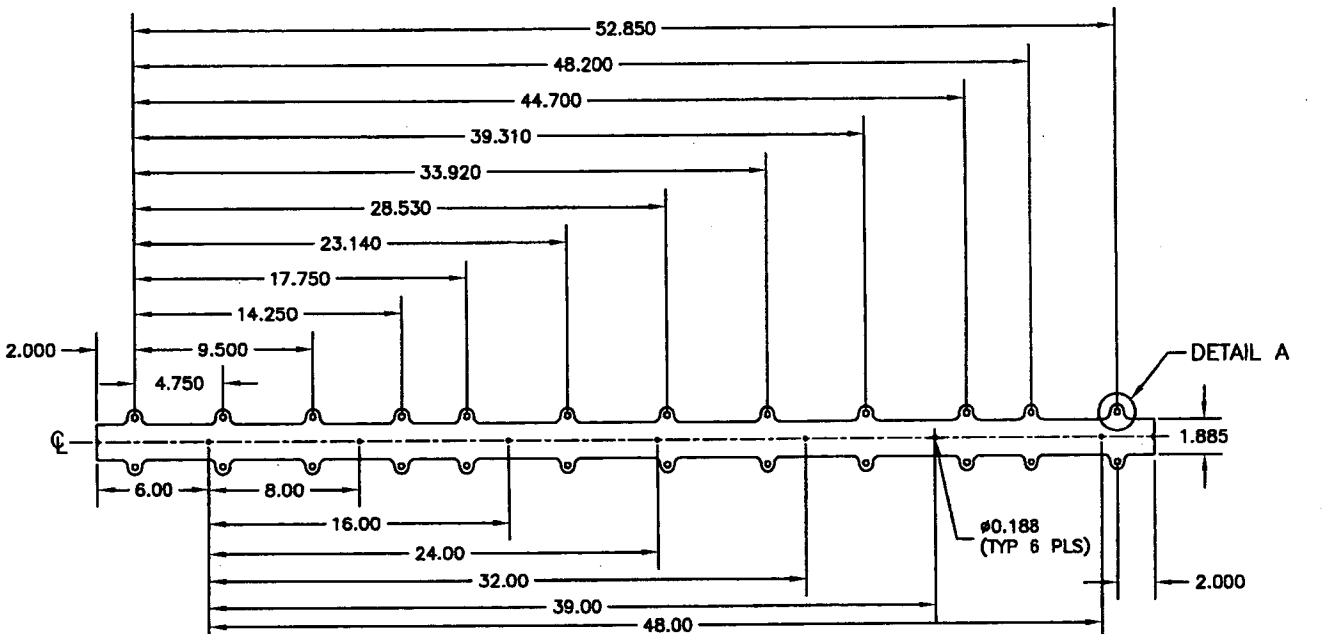
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- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**DART**

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07.04.24

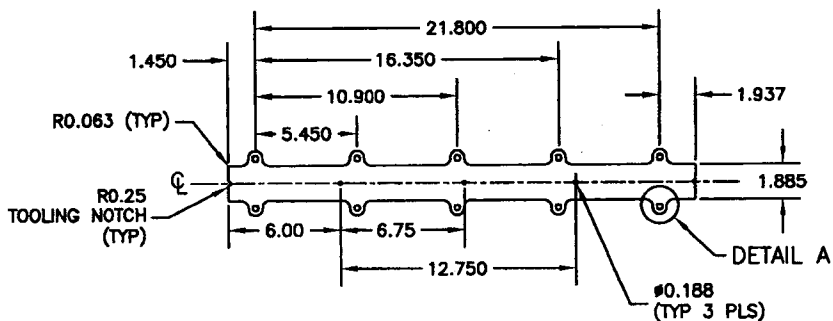
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CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	Wearshoe
		SCALE	1:10	
		SHEET 3 OF 7		
		REV. B		



**D3535-23F FLAT PATTERN**

**D3535-23 BEND DETAIL**

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WORK ORDER  
NO. 60336



**D3535-25F FLAT PATTERN**

**D3535-25 BEND DETAIL**

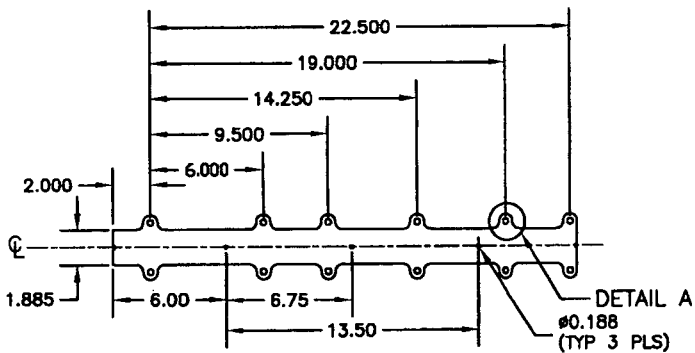
**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**DART**

RELEASED

07.04.24



**D3535-31F FLAT PATTERN**

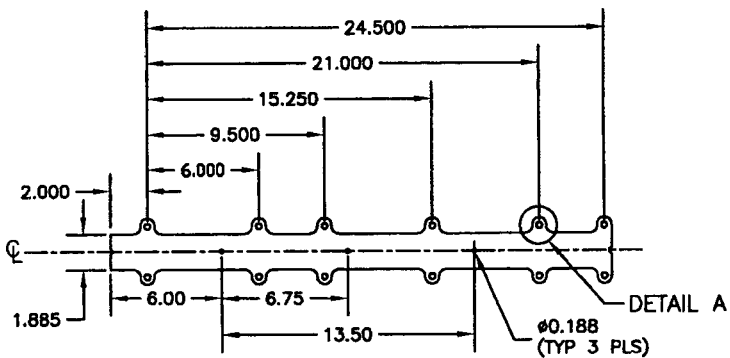


**D3535-31 BEND DETAIL**

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WITHOUT NOTICE  
WORK ORDER  
NO. 66236

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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**D3535-33F FLAT PATTERN**



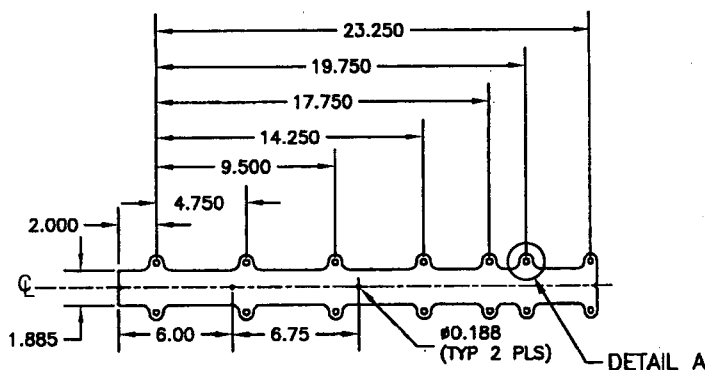
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CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3535	SHEET 4 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	

**DART**

RELEASED

07.04.24



**D3535-35F FLAT PATTERN**

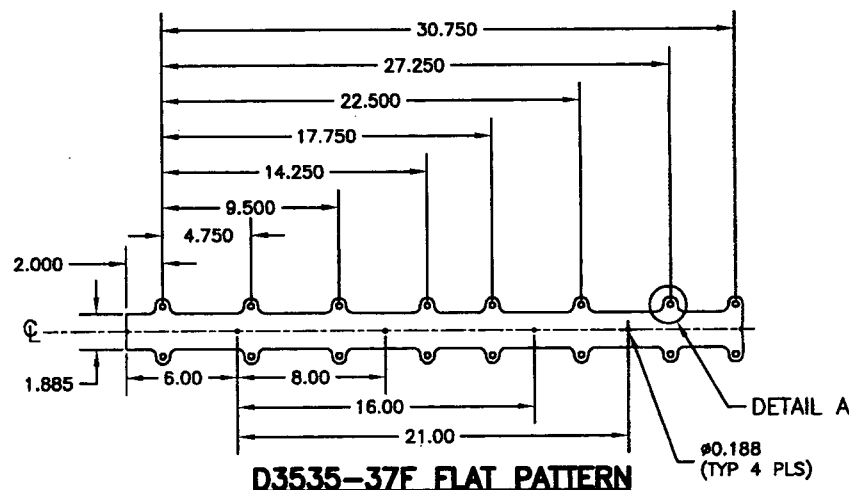


**D3535-35 BEND DETAIL**

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WORK ORDER  
NO. 66236

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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- 8) SEE PAGE 7 FOR DETAILS AND SECTION



**D3535-37F FLAT PATTERN**



**D3535-37 BEND DETAIL**

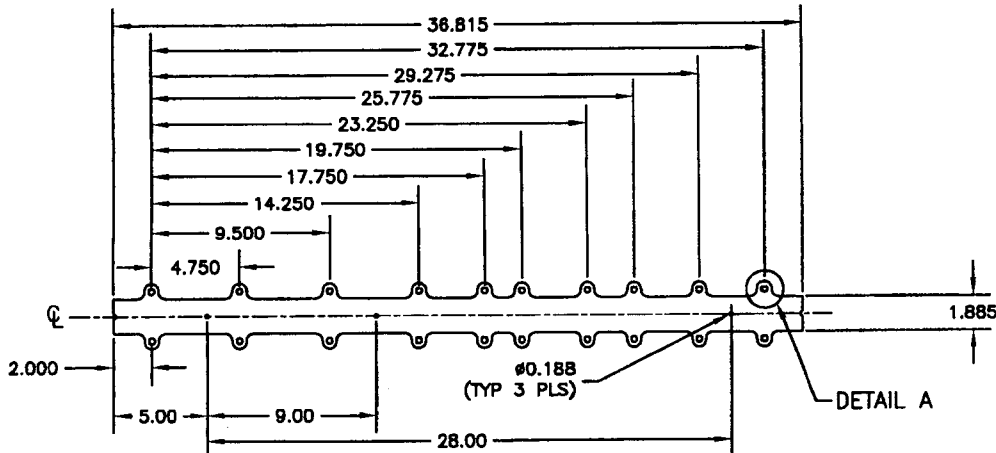
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CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3535	SHEET 5 OF 7
DATE	TITLE	WEARSHOE	SCALE
07.04.17			1:10

**DART**

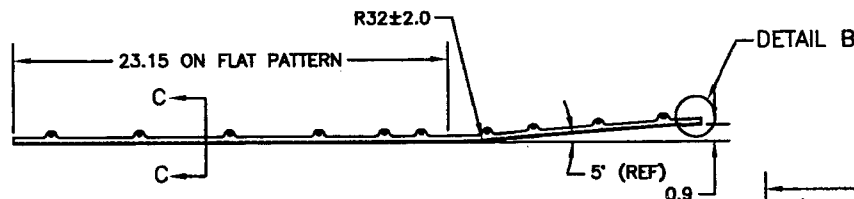
RELEASED

07.04.24

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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 6 OF 7
		SCALE	1:10	

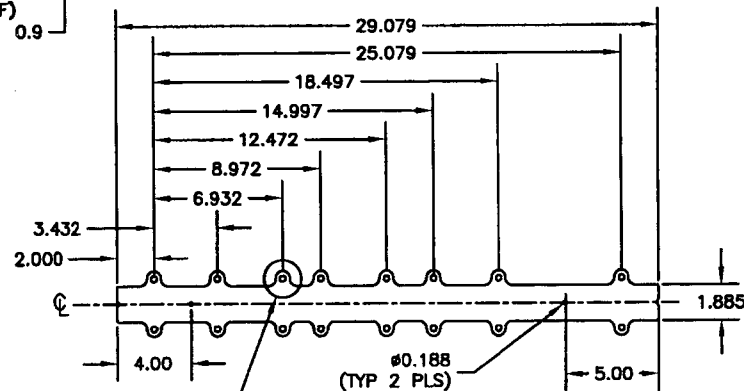


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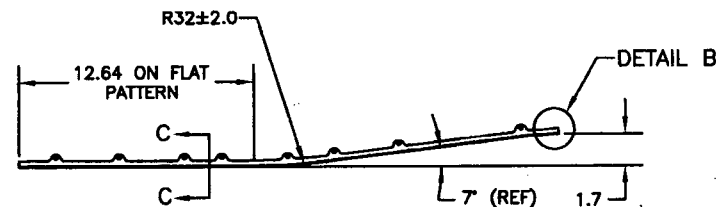


**D3535-39 BEND DETAIL**

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WITHOUT NOTICE  
WORK ORDER  
NO. 66236



**D3535-41F FLAT PATTERN**



**D3535-41 BEND DETAIL**

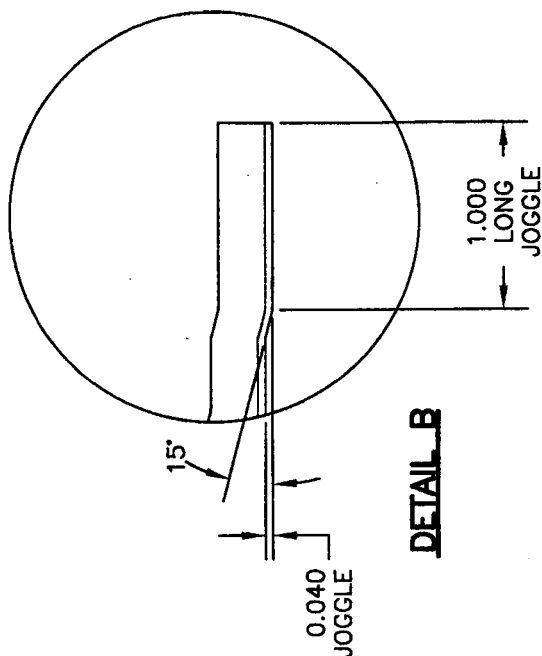
**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



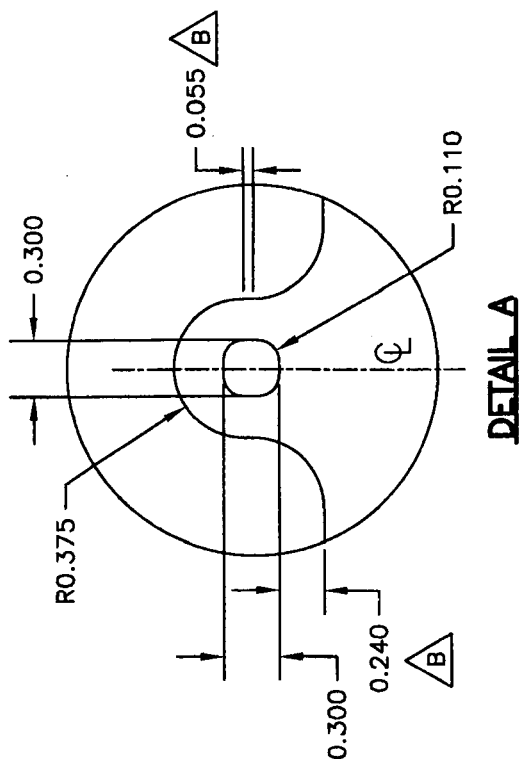
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CHECKED 	APPROVED 	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17		TITLE WEARSHOE	SCALE 1:1

RELEASED  
07.01.24

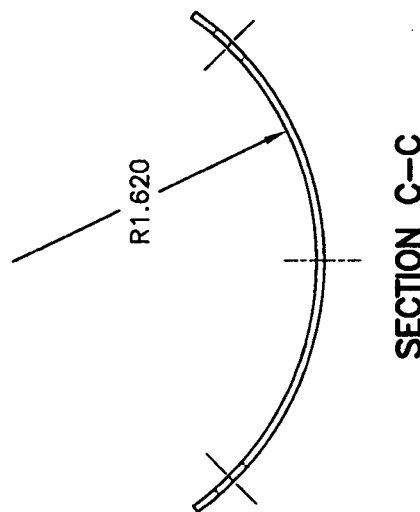


**DETAIL B**

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 66238



**DETAIL A**



**SECTION C-C**

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